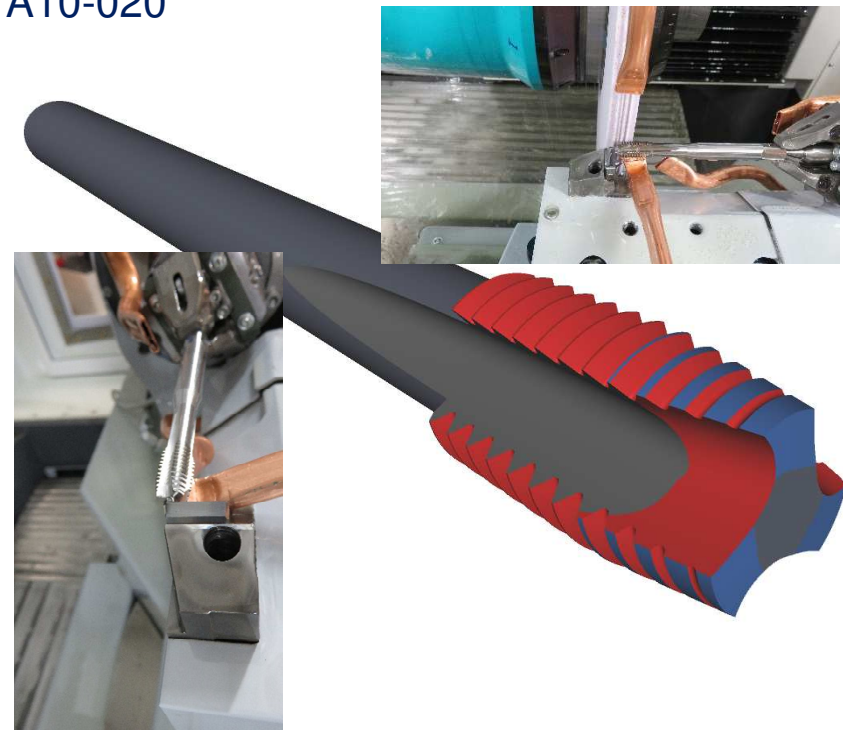


**Tap M10 Ø10.1, Z3, Helix 0°**

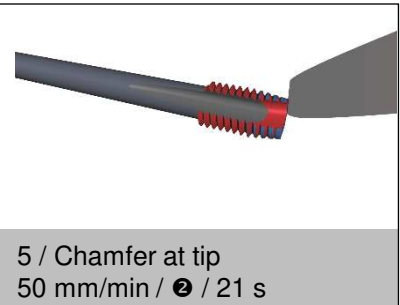
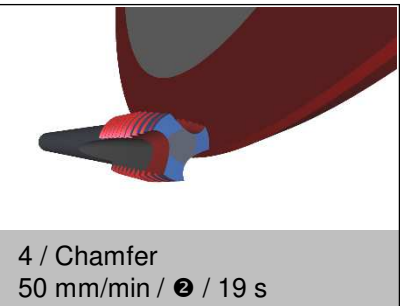
A10-020



**Tool**  
The 3 fluted Tap M10 with straight flute is ground from solid cylindrical blank between centers. A special clamping acts as dog and drive system on the square at the shafts end. Flutewheel and threading Formwheel are dressed in the cycle.

**Blank**  
Dimension: Ø 10.15/ Ø 7.5/ Ø 10mm, L 100mm  
HSS

N° / Process description Feed rate / Wheel / Time		
1 / Plungedress Threadwheel	0.4 mm/min / ③ / 20 s	
1 / Flute	2000 mm/min / ① / 62 s	
2 / Gashing	2000 mm/min / ① / 26 s	
3 / Thread	50 mm/min / ③ / 50 s	
4 / Chamfer	50 mm/min / ② / 19 s	
5 / Chamfer at tip	50 mm/min / ② / 21 s	



**Total cycle time: 3 Min 20 s**

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



- Machine / Configuration**
- Machine: Gemini NGM TAP Robot
  - Control: Fanuc 31iB
  - Accessories: 2 Dressing Units, Tailstock for Taps,

